

Work Order ID 77139

77139

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November-25-11 3:14:50 PM

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Lid Assembly (350)
 Start Date: 25/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	B

100 Weld per dwg A/R S.S. rod Batch: 4115778 0.00
100 Large Fab
 Memo 0.00
 1- assemble ribs, weld as per dwg D3914 using DT9607A
 2- weld hinge (3) and Mounting brackets as per dwg D3914
 inspect before welding mesh
 3- tack weld mesh on basket as per dwg D3914
 make sure to place mesh correctly on lid, check with label plate before tacking mesh

11-12-22 (1X)

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110 QC
 Memo 0.00
 Quality Control

11-12-29 1X

W/O:		WORK ORDER CHANGES					
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120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating									

*** mask sides of hinge prior to powdercoat***
 Start Time: 10:35
 Oven Temperature: 3200F
 Finish Time: 11:20

140	Wing Walk as per dwg QSI005 4.4 Batch 11994	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg
 2- Install placard and label as per dwg
 Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label

1X4M-11/12/28

1 BL 11-12-28

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150 QC3- Inspect Part Finish 0.00

150

QC

Memo

Quality Control

160 Identify as per dwg & Stock Location: 77140 0.00

160

Packaging

Memo

Packaging

170 QC21- Final Inspection - Work Order Release 0.00

170

QC

Memo

Quality Control

8 u11/2/29
1 B 11-12-29
CK 12/01/02
u11-12-29

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Picklist Print

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Work Order ID: 77139

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Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2581

Manufactured

No

100

Each

40.0000

2

2

D2581

Mounting Bracket

**

dy 11/12/21

Location

Loc Qty

Loc Code

WA

40

69739

2

70766

2

73762

11

75280

25

2x

D3914-1

Manufactured

No

100

Each

0.0000

2

2

D3914-1

Rib

**

B74132 → 1x dy 11/12/21

✓ D3914-7

Manufactured

No

100

Each

6.0000

2

B274637 → 1x

D3914-7

Rib

**

dy 11/12/21

Location

Loc Qty

Loc Code

WA

4

75459

4

WA006

2

73942

2

2x

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Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-3 Manufactured No

100 Each

25.0000

3

3

**

SY 11/12/21

✓ *D4016-3*

Hinge Half, Lid

Location

Loc Qty

Loc Code

WA

24

73630

6

74909

18

WA005

1

71941

1

3x

✓ D4018-5

Manufactured No

100 Each

19.0000

9

9

**

SY 11/12/21

D4018-5

Rib

Location

Loc Qty

Loc Code

WA

18

74917

18

WA005

1

74636

1

8x

1x

✓ D4020-5

Manufactured No

100 Each

1.0000

1

1

**

SY 11/12/21

D4020-5

Mesh (350 Basket Long, Lid)

Location

Loc Qty

Loc Code

WA

1

73935

1

100

Each

2.0000

1

1

**

SY 11/12/21
~~B 76331~~
B 73935 → 1x

D4021-3

Manufactured No

Location

Loc Qty

Loc Code

WA

2

73632

2

1x

✓ *D4021-3*

Data Plate

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D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-041

Manufactured No

100

Each

5.0000

1

1

D4035-041

Lid Rib Assembly, Fwd (350 Basket)

**

dy 11.12.21

Location

Loc Qty

Loc Code

WA

5

63720

0

74818

1

76332

4

1x

✓ D4035-043

Manufactured No

100

Each

3.0000

1

1

D4035-043

Lid Rib Assembly, Aft (350 Basket)

**

dy 11.12.21

Location

Loc Qty

Loc Code

WA

3

74808

3

1x

D2728-3

Manufactured No

140

Each

0.0000

1

1

D2728-3

Dart Logo label

**

1 BR 11-12-28.

15050

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

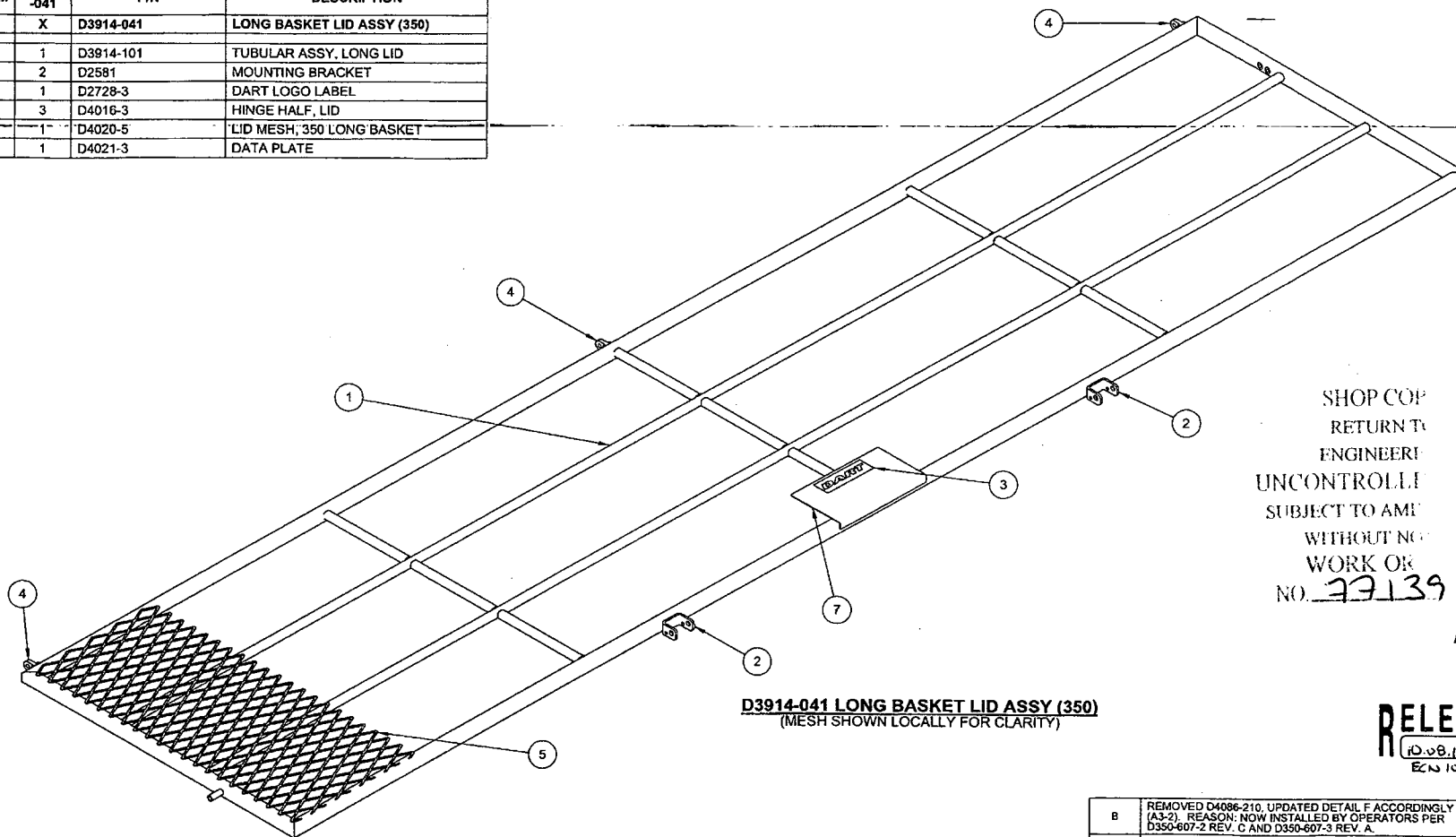
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COP
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO AMT
WITHOUT NO
WORK OR
NO. 37139 M.L.J
11/11/25

RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ALS		
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	ALS	D3914	SHEET 1 OF 4
APPROVED	ALS	TITLE	SCALE
DE APPR.	ALS	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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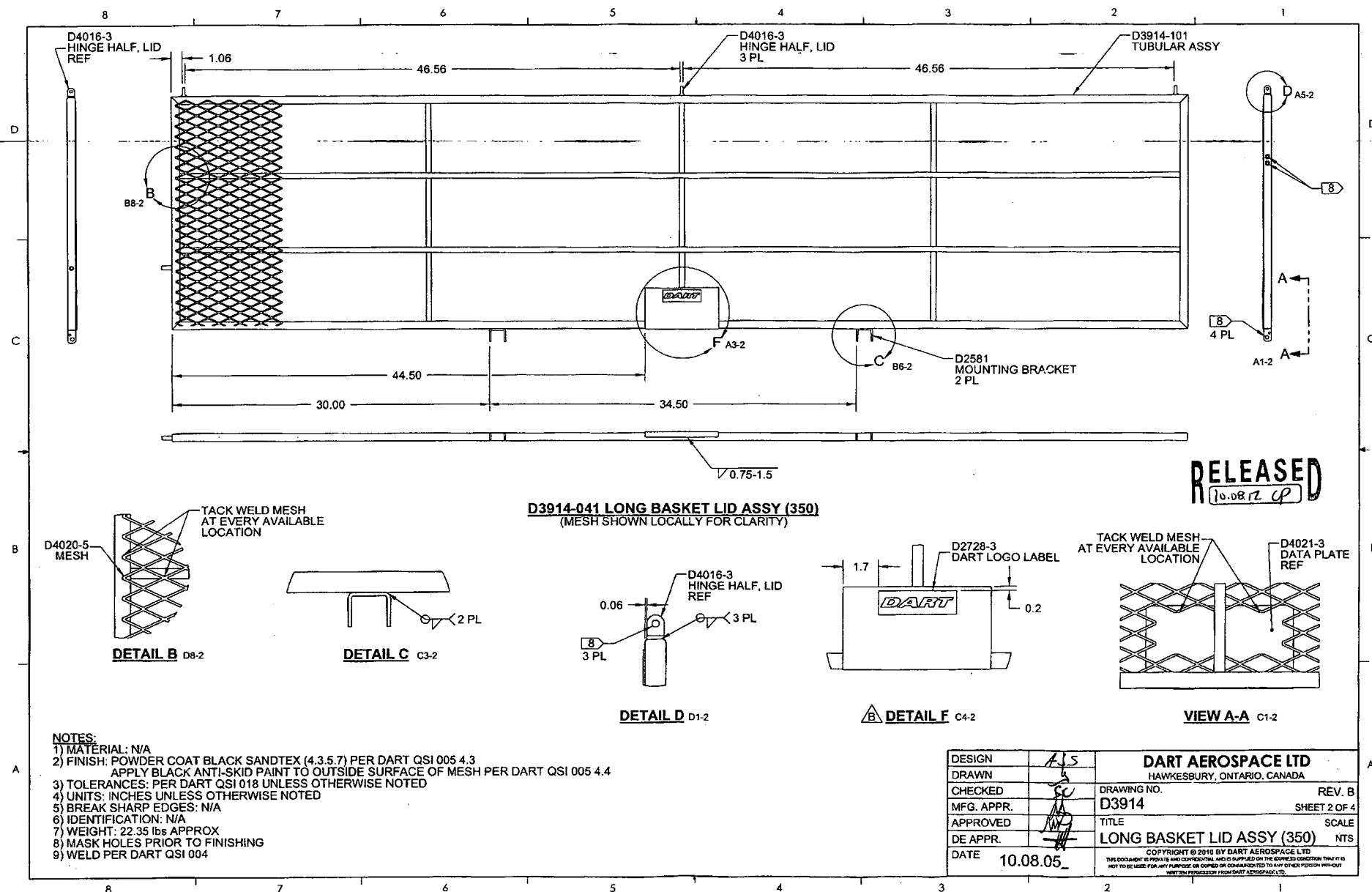
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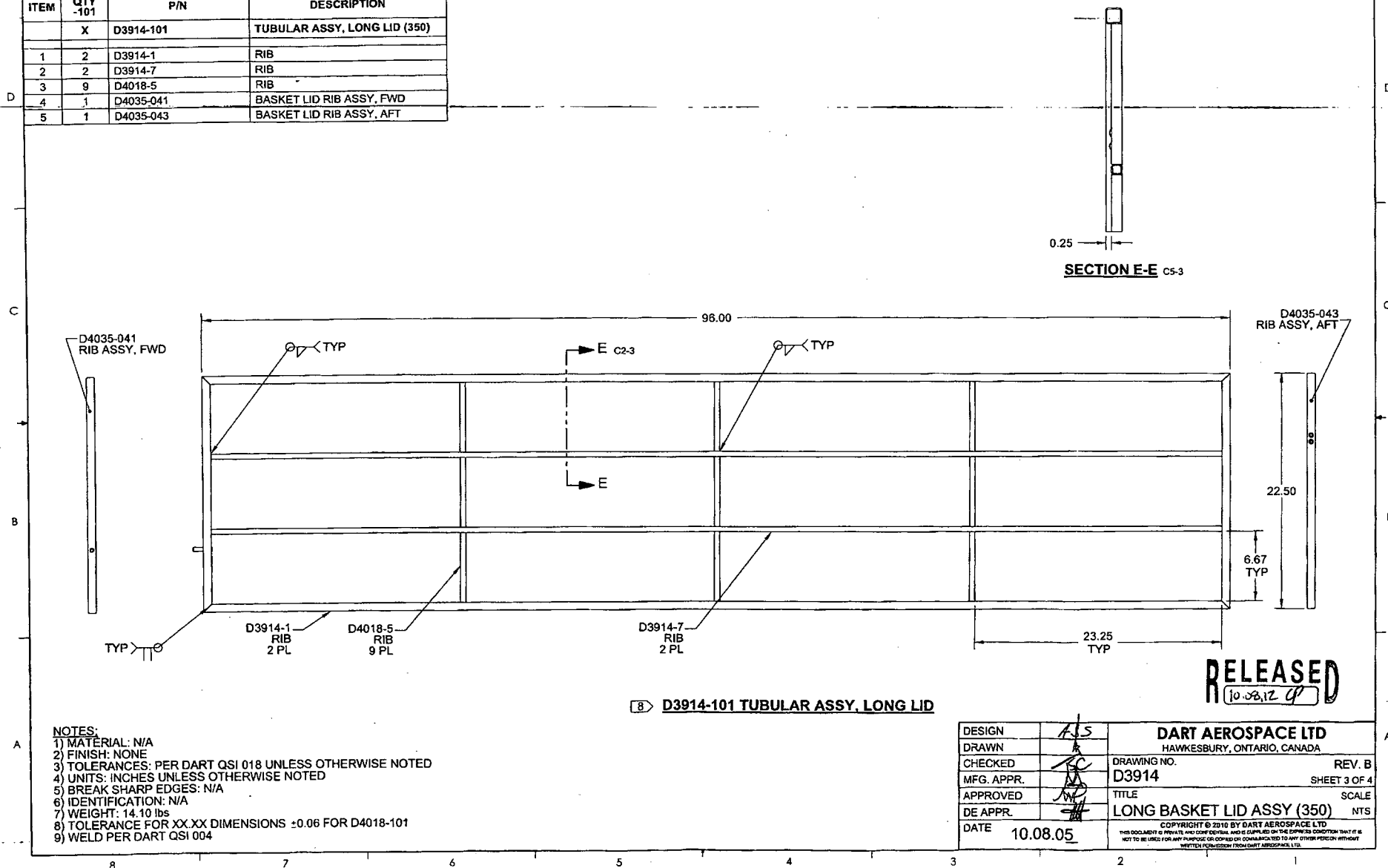
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-05

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ±0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	AC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AC	DRAWING NO.	REV. B
MFG. APPR.	MP	D3914	SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	LONG BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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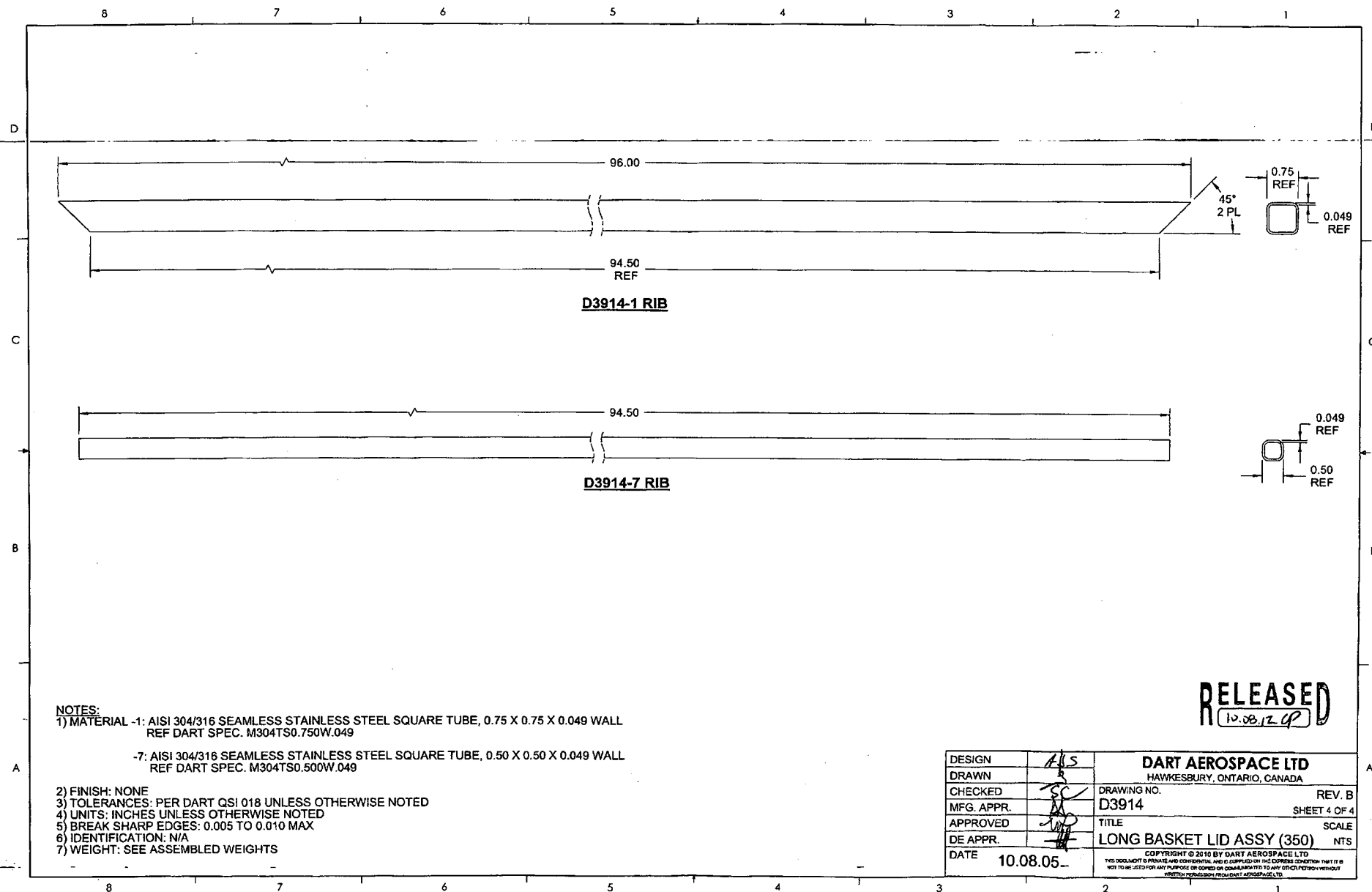
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